

2

ASAP

Order ID 116042-1

April 04, 2014 2:01:49 PM

116042

Page 1

D: D4021-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Hoop

Stop *NS2*

Start Date: 4/04/14 Start Qty: 40.00

40
40 28

Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-10

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4021	B								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg. 14021

Prog Rev: B

Dwg Rev: B

Deburr as required

0.00

28 0

Jm 14-05-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

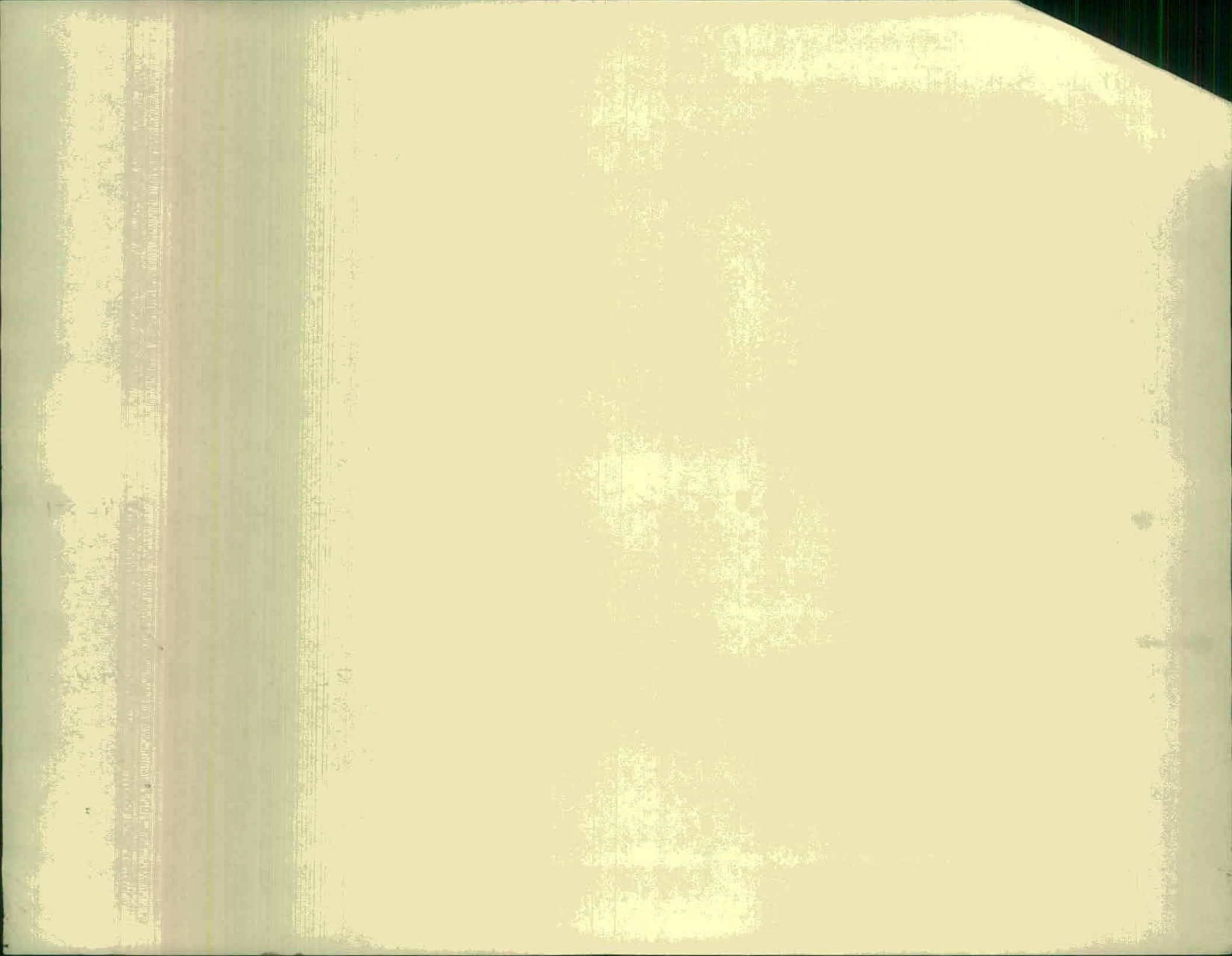
Quality Control

Memo

0.00

28 0

Jm 14-05-1



Work Order ID 116042

Friday, April 04, 2014 2:01:50 PM

116042

Page 2

Item ID: D4021-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hoop

Start Date: 4/04/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

130

130

Small Fab

Small Fab

Memo

1- make radius as per dwg
2- deburr

0.00

0.00

140

QCS- Inspect part completeness to step on W/O

0.00

140

QC

Memo

Quality Control

0.00

DAS
43
9-89

28x

14-5-6

PM
14/5/2

28

28

02/4-5-5

808

Work Order ID 116042

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116042

Page 3

Item ID: D4021-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hoop

Stop

NS2

Start Date: 4/04/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

WWA004

28x

DAS
43
9-88

14-5-6

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/5/7

14-05-06

100

Picklist Print

Friday, April 04, 2014 2:01:49 PM

Page 1

Work Order ID: 116042

116042

Parent Item: D4021-7

D4021-7

Parent Item Name: Hoop

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg REV.A DD 10.02.22 verified by:EC
DD 10.04.20 verified by:EC
IPP Rev:B as per dwg revB
IPP Rev C as per dwg revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.625X3.000

Purchased

No

100

f

8.0000

0.4166

~~17.54105~~

M304B0 625X3 000

**

JM14-05-1

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT049

8

m127015

6

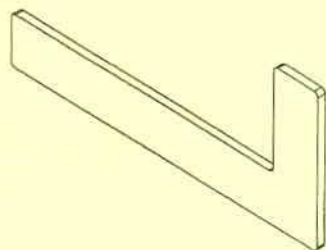
m127612

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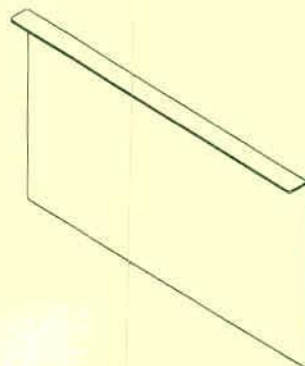
127015 - 6
127612 - 2

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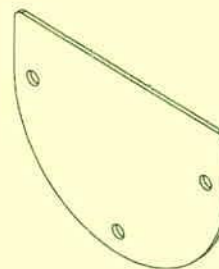
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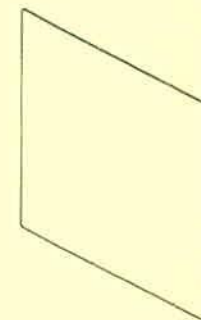
D4021-1 HANDLE PLATE



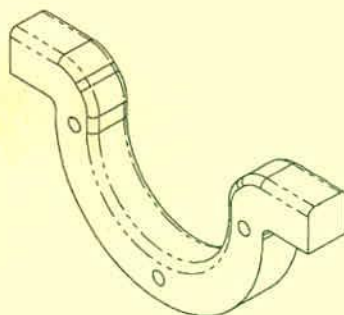
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



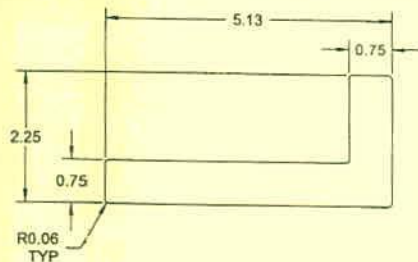
D4021-9 BUSHING

116042 MJS
14-04-10

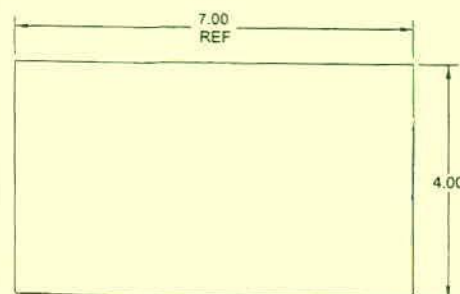
RELEASED
2010-04-14

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	1004.06
A	NEW ISSUE	JPH	1001.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4021	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

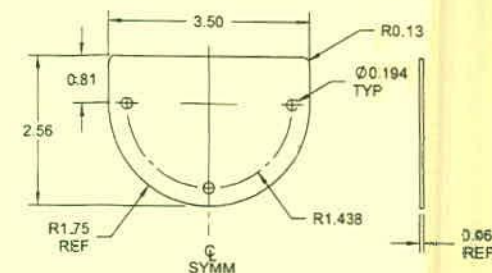
8 7 6 5 4 3 2 1



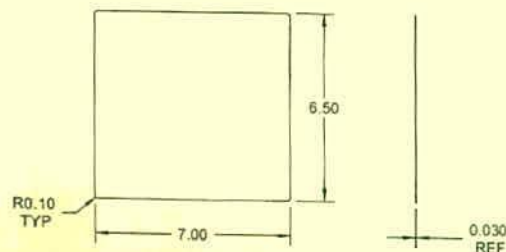
D4021-1 HANDLE PLATE



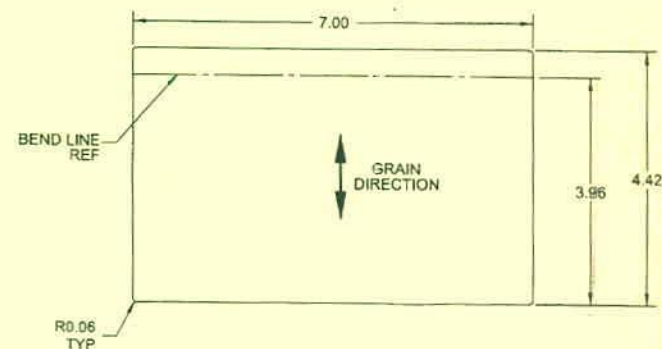
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



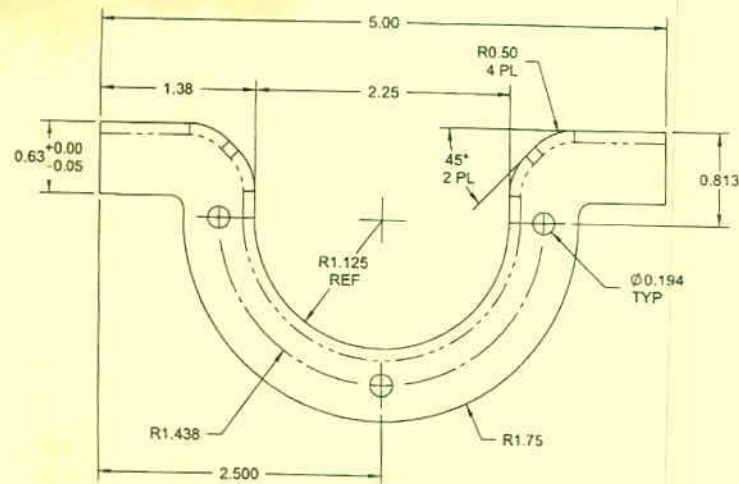
D4021-3F DATA PLATE
FLAT PATTERN

- NOTES:**
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
 - 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
 - 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

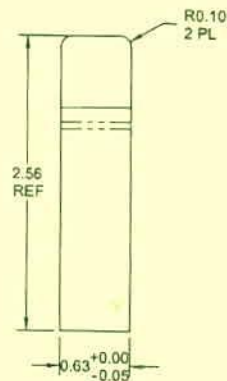
- 2) FINISH:**
- 1/-3/-11: NONE
 - 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

RELEASED
R 2010-04-16
NM

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTE
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR BEING REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4021-7 HOOP



D4021-9 BUSHING

RELEASED
2010-04-14
NR

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	INTS
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